

Date: Wednesday, 02/04/2008 11:27:30 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|----------------------------------|---|-------------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BRACKET |
| Job Number | : 38296 | | |
| Estimate Number | : 12840 | | |
| P.O. Number | : | Part Number | : D35421 |
| This Issue | : 02/04/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D3542 REV A |
| First Issue | : / / | Project Number | : N/A |
| Previous Run | : 34221 | Drawing Revision | : A |
| Written By | : | Material | : |
| Checked & Approved By | : <u>JLO 08.4.02</u> | Due Date | : 16/04/2008 |
| Comment | : Est Rev: A New Issue 07-04-23 JLM Est Rev: B updated powder coat per NCR 07.05.16 EC | Qty: | 20 |
| | | Um: | Each |

*Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-----------------------|
| 1.0 | M6061T6B3000X01500 | 6061-T6 Bar 3" x 1.5" |
|-----|--------------------|-----------------------|



Comment: Qty.: 0.3500 f(s)/Unit Total: 6.9993 f(s)

6061-T6 Bar 3" x 1.5"

BATCH: MIL530

ml 08/04/08 21

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

Cut blank 4.0" long

ml 08/04/08 21

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA684 Rev: AA & Dwg D3542 Rev: A

2-Deburr per dwg D3443

H.A. ml 08/04/08 (21)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A. ml 08/04/08 (21)

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

H.A. ml 08.4.09 21

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 38296

Part Number: D35421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(21)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-04-14.

7.0

POWDER COATING

POWDER COATING



m 106442

Comment: POWDER COATING

Powder Coat Grey sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*****ENSURE TO MASK INSIDE BORE*****

FL 08/04/15

(21)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(21)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-04-15

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 243A

8/4/15

SD

(21X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



cmf 08-04-16

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

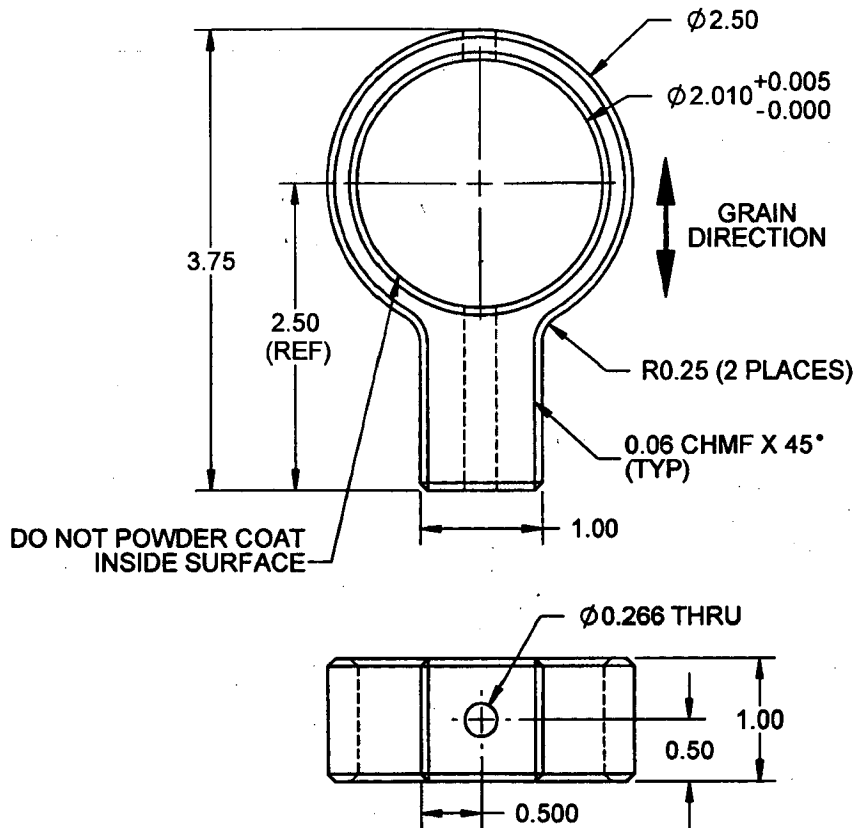
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|-------------------------|---|--|------------------------|
| DESIGN <i>LE</i> | DRAWN BY <i>LE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>B</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3542 | REV. A SHEET 1 OF 1 |
| DATE 06.11.27 | TITLE BRACKET SCALE 2:3 | | |
| REV A | DATE 06.11.27 | DESCRIPTION NEW ISSUE | |

RELEASED
07.04.02

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38296

D3542-1 BRACKET**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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